

# Work Order ID 119742

May-21-14 9:20:05 AM

\*119742\*

TO Rev & Eng Sign-off  
**PRELIMINARY ISSUE**

Page 1

Item ID: D3910-7 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: PRELIM Stop **\*NS2\***  
Item Name: Crosstube Lug  
Start Date: 5/21/14 Start Qty: 60.00 **\*60\*** Cust Item ID:  
Required Date: 5/27/14 Req'd Qty: 60.00 **\*60\*** Customer: /  
Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3910	<del>PE1</del> Rev E Sign-off 5/21/14								
110	Outsource process - Machining	0.00							
<b>*110*</b>	HAAS CNC VERTICAL MACHINING #1								u 14.0521
Outsource5	Memo	0.00							
Outsource process - Machining	Issue P/O to Metec : <u>24278</u> Machine as per dwg C of C is required								
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
<b>*120*</b>									
Packaging	Memo	0.00							
Packaging	Ensure C of C is attach								
130	QC6- Inspect dimensions to drawing	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									



68-6  
27  
DAS

14/6/13

14/6/13 (60)

60  
can

Work Order ID 119742

May-21-14 9:20:06 AM

\*119742\*

PRELIMINARY ISS

Page 2

Item ID: D3910-7 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: PRELIM Stop \*NS2\*  
 Item Name: Crosstube Lug  
 Start Date: 5/21/14 Start Qty: 60.00 \*60\* Cust Item ID:  
 Required Date: 5/27/14 Req'd Qty: 60.00 \*60\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
*140*						60	246	14-6-16	
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
*150*						60	φ	14-6-16	DAS 34 9-89
QC	Memo	0.00							
Quality Control									
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
*160*	M 108027					60	φ	14-6-16	DAS 34 9-89
Powdercoat	Memo	0.00							
Powder Coating	START TIME 11:05. OVEN TEMPERATURE 320 FINISH TIME 11:35.								

Work Order ID 119742

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\*119742\*

PRELIMINARY ISSUE

Page 3

Item ID: D3910-7

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID: PRELIM

Item Name: Crosstube Lug

Stop

\*NS2\*

Start Date: 5/21/14

Start Qty: 60.00

\*60\*

Cust Item ID:

Required Date: 5/27/14

Req'd Qty: 60.00

\*60\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

DAS  
27  
9-89

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

QC3- Inspect Part Finish

0.00

\*170\*

QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 140526 AUTH

RELEASED 8 DATE 140617

0.00

180

Identify as per dwg & Stock Location: ST

\*180\*

Packaging

Memo

0.00

Packaging



DAS  
28  
9-89

JUN 16 2014

190

QC21- Final Inspection - Work Order Release

0.00

\*190\*

QC

Memo

0.00

Quality Control

ML5 14-06-17

14.6.16

# Picklist Print

May-21-14 9:20:05 AM

Page 1

Work Order ID: 119742

**\*119742\***

Parent Item: D3910-7

**\*D3910-7\***

Parent Item Name: Crosstube Lug

Start Date: 5/21/14

Required Date: 5/27/14

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP REV:A 14.05.21 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423

Manufactured

No

f

421.7828

8

**\*D2423\***

Lug Extrusion

**\*\***

*CL 14/05/21*

Location

Loc Qty

Loc Code

HALL

421.782848

105422

53.666848

115529

368.116

D3910-7P

Purchased

No

Each

0.0000

60

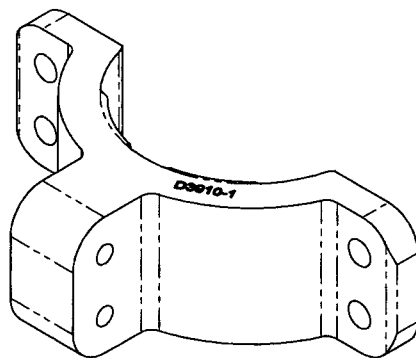
**\*D3910-7P\***

Crosstube Lug

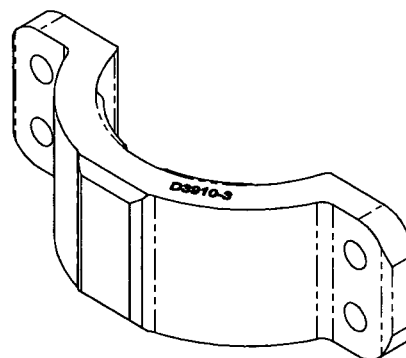
**\*\***

*14/4/13 CL*

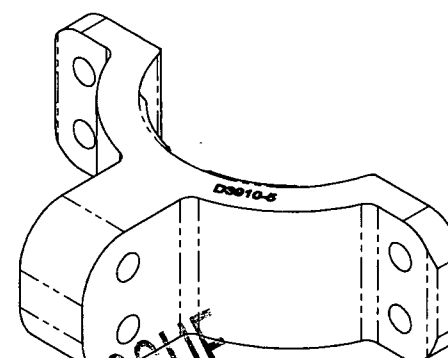
PRELIMINARY ISSUE  
PRELIMINARY ISSUE



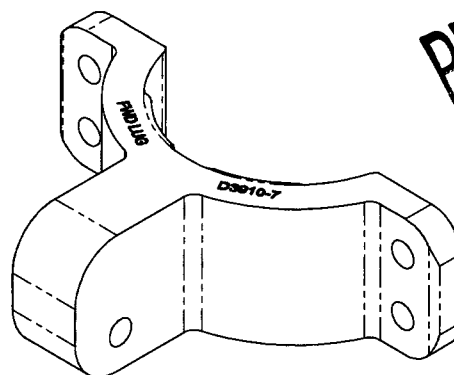
**D3910-1 X-TUBE LUG**



**D3910-3 X-TUBE LUG**



**D3910-5 X-TUBE LUG**



**D3910-7 X-TUBE LUG**

**NOTES:**

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT -1: 0.32 lbs  
-3: 0.25 lbs  
-5: 0.36 lbs  
-7: 0.37 lbs
- 8) IDENTIFICATION: ENGRAVE "FWD LUG" TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005

**PRELIMINARY ISSUE**

*also  
14.05.16*

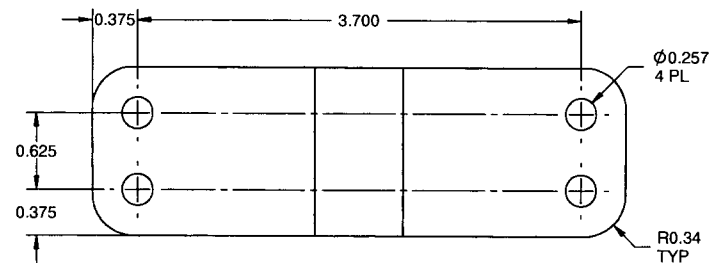
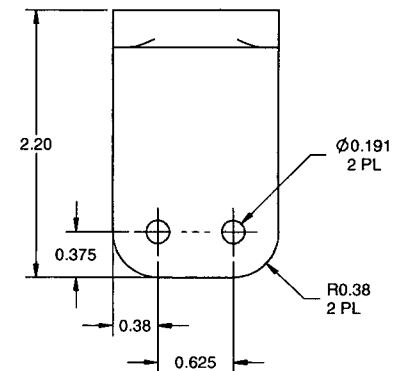
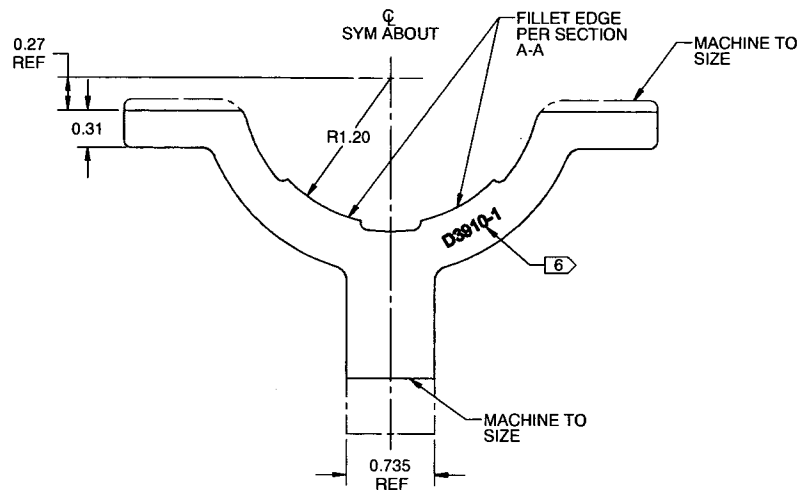
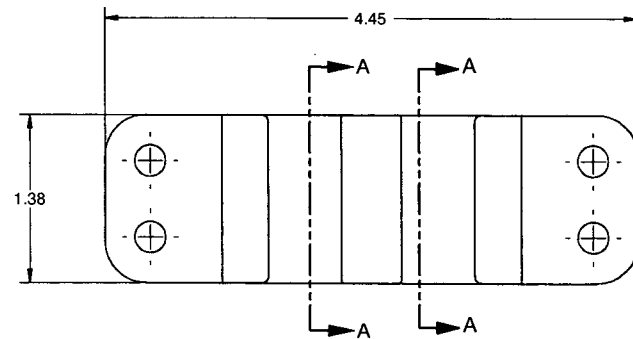
**PRELIMINARY E1**  
14.05.16 AJS

PE1	PRELIM: ADD -7 PER NCR14-3871	AJS	14.05.16
D	CHANGED FASTENER HOLES IN -5 FOR 1/4" HARDWARE. REASON: EASE OF INSTALLATION.	AJS	13.08.14
C	ADD -5.	AJS	13.08.08
B	Ø 0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-607-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. PE1
MFG. APPR.		D3910	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
DATE	14.05.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



ROUND EDGE  
R0.06 MIN - R0.10 MAX  
2 PL

**SECTION A-A**



**D3910-1 X-TUBE LUG**

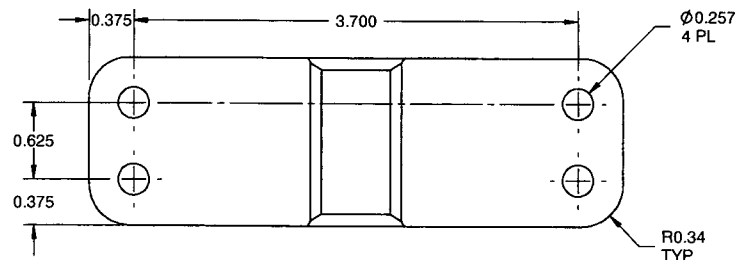
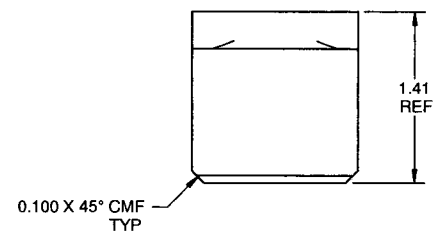
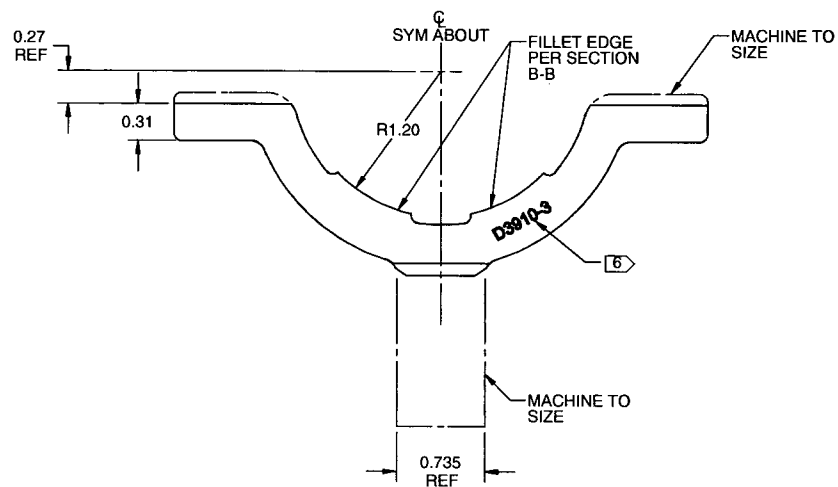
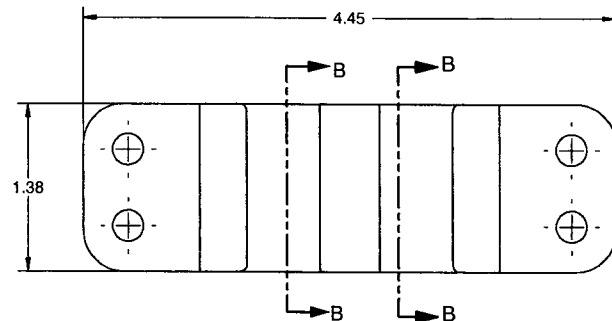
**PRELIMINARY E1**  
14.05.16 AJS

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PE1
MFG. APPR.		D3910	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
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ROUND EDGE  
R0.06 MIN - 0.10 MAX  
2 PL

**SECTION B-B**



**D3910-3 X-TUBE LUG**

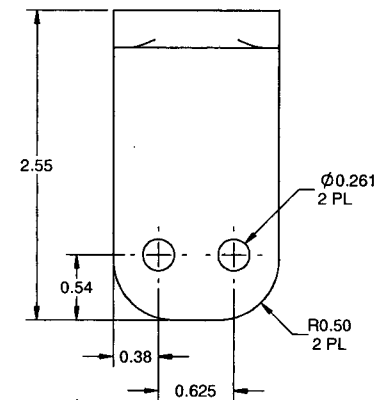
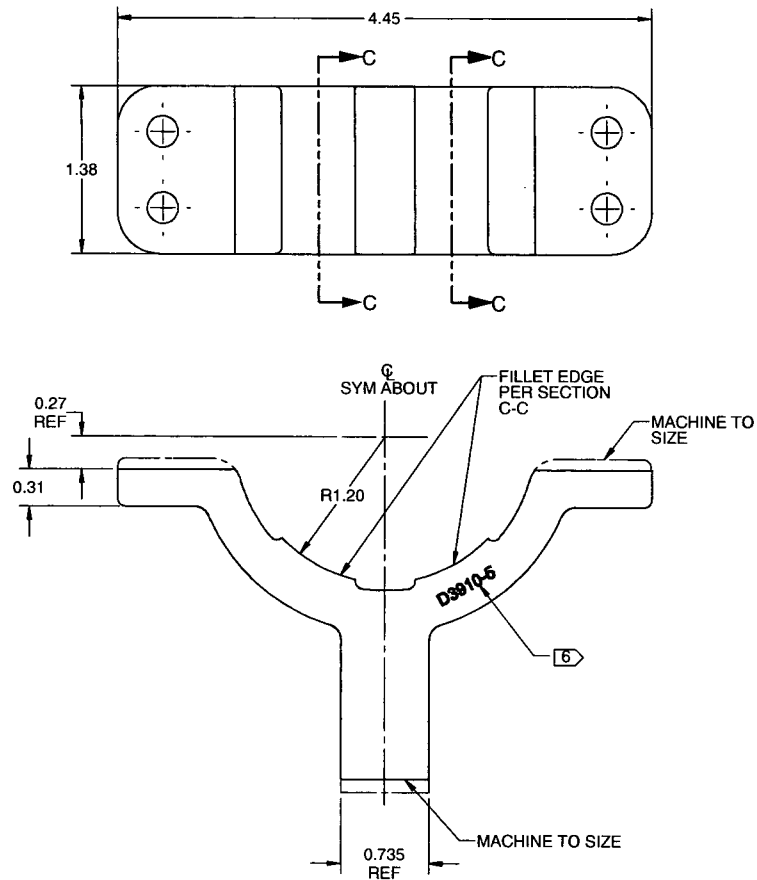
**PRELIMINARY E1**  
14.05.16 AJS

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PE1
MFG. APPR.		D3910	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
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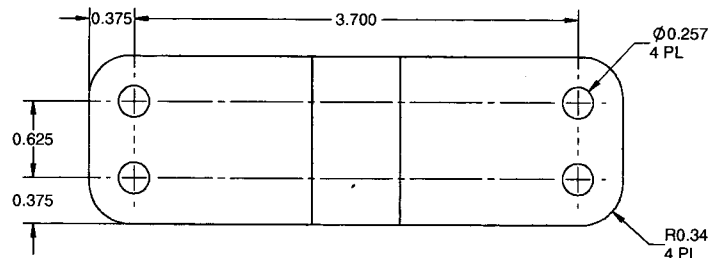
**SECTION C-C**



ROUND EDGE  
R0.06 MIN - 0.10 MAX  
2 PL



**PRELIMINARY E1**  
14.05.16 AJS



**D3910-5 X-TUBE LUG**

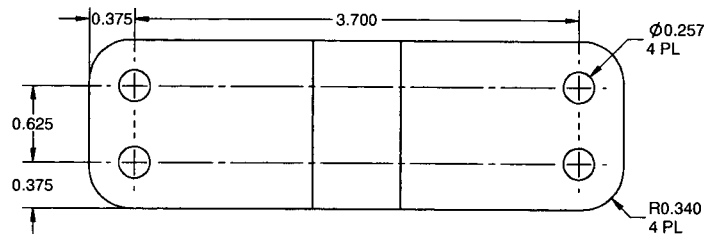
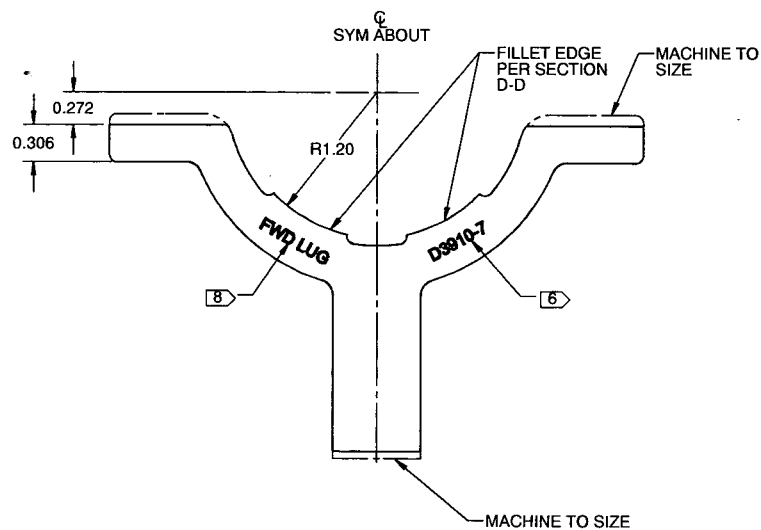
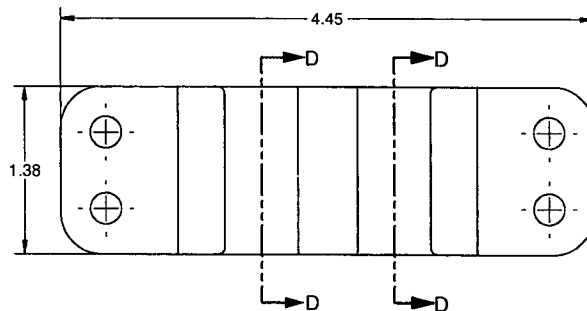
DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PE1
MFG. APPR.		D3910	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
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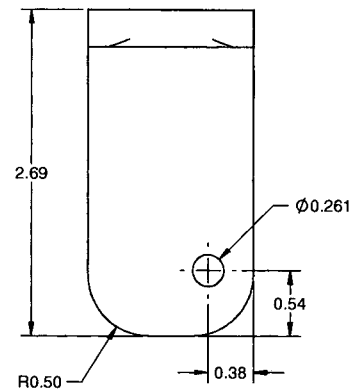
**SECTION D-D**



ROUND EDGE  
R0.06 MIN - 0.10 MAX  
2 PL



**D3910-7 X-TUBE LUG**



**PRELIMINARY E1**  
14.05.16 AJS

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PE1
MFG. APPR.		<b>D3910</b>	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>X-TUBE LUG (350)</b>	NTS
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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO24278**

Purchase Order Date 5/21/2014

PO Print Date 5/21/2014

Page Number 1 of 2

Order From :  
METEC METAL TECHNOLOGY INC.  
20 TERRY FOX DRIVE PO BOX 781  
VANKLEEK HILL, ON K0B 1R0  
CA

VC-MET003

Ship To : DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Contact Name  
Vendor Phone 613 678 3957

Ship To Contact  
Ship To Phone  
Ship Via:  
Ship Acct:

Buyer  
Customer POID  
Customer Tax # 10127-2607  
Terms Net 10  
Currency CAD  
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3910-7P  PER DRWG D3910 PE1	Crosstube Lug	5/21/2014 Yes 5/22/2014		10.00 Each	\$31.55	\$315.50
Line Total:							\$315.50
2	D3910-7P  PER DRWG D3910 REV.PE1 ***DO NOT PRODUCE THESE 60 UNTIL WE TRIAL FIT THE FIRST 10...TBA BY FRIDAY 23/05***	Crosstube Lug	5/21/2014 Yes 5/27/2014		60.00 Each	\$31.55	\$1,893.00
Line Total:							\$1,893.00

PO Instructions:

Note:

5/21/2014



20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0 , Canada  
Tel: (613) 678-3957  
Fax: (613) 678-3956

**Delivery Slip No.:** 20028  
**Date:** Jun 13, 2014  
**Page:** 1

<b>Sold to:</b>  <b>Dart Aerospace Ltd.</b> Att. Micheal Gregoire 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	<b>Ship to:</b>  Dart Aerospace Ltd. Att. Micheal Gregoire 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
<b>Order No.:</b> 24278	<b>Sold By:</b> Dewar, Eric
<b>Shipped By:</b> your truck	<b>Ship Date:</b> Jun 13, 2014

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
3910-7 Crosstube Lug, as per drawing D3910 PE1	Each	10		
3910-7 Crosstube Lug, as per drawing D3910 REV. PE1 Batch 1105422 and B115529	Each	60	60	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 [metec@metec.ca](mailto:metec@metec.ca)

## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
60	D 3910-7	Crosstube Lug	24278

MATERIAL: supplied by DART B115529 (28)  
B105422 (32)

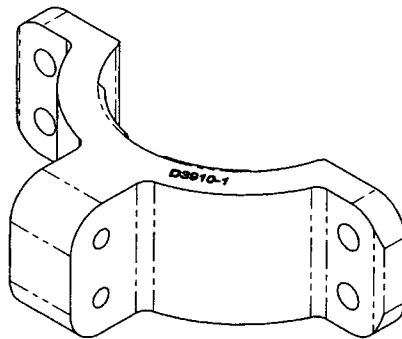
We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

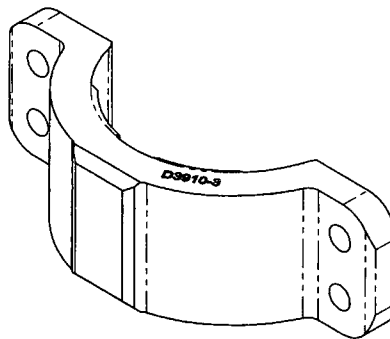
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Jan Norris

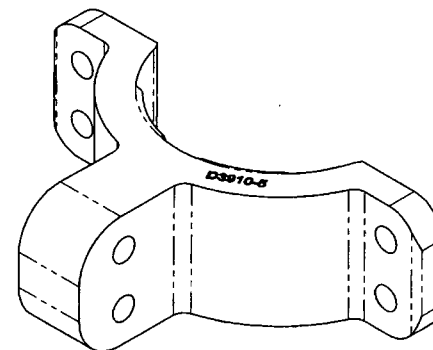
Vankleek Hill, June 13 2014



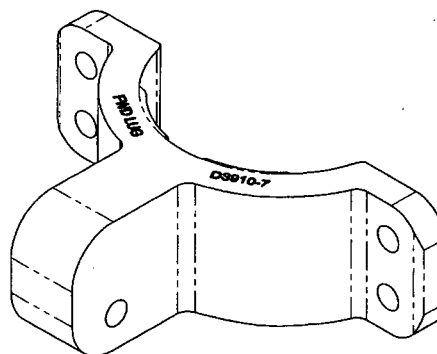
**D3910-1 X-TUBE LUG**



**D3910-3 X-TUBE LUG**



**D3910-5 X-TUBE LUG**



**D3910-7 X-TUBE LUG**

**NOTES:**

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT -1: 0.32 lbs  
-3: 0.25 lbs  
-5: 0.36 lbs  
-7: 0.37 lbs
- 8) IDENTIFICATION: ENGRAVE "FWD LUG" TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005

**RELEASED**

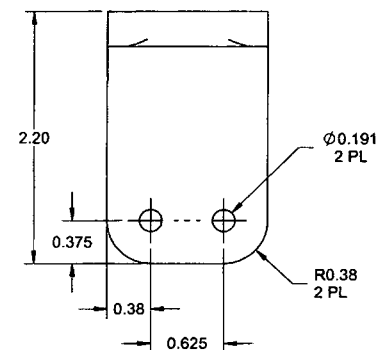
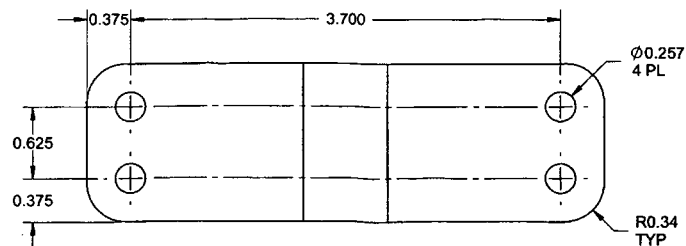
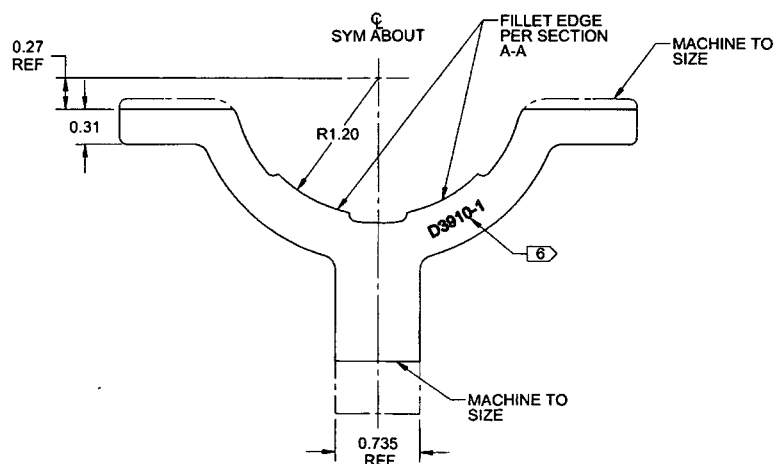
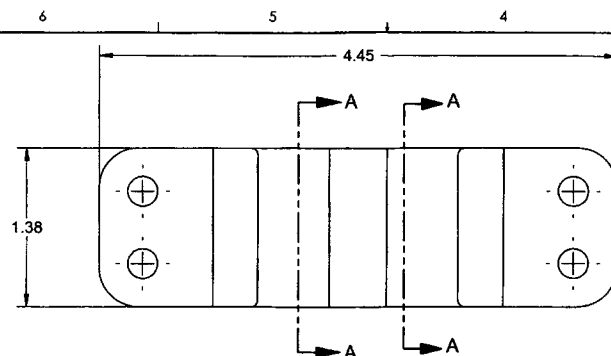
2014 JUN 05  
ECN 14-572

REV.	DESCRIPTION	BY	DATE
E	ADD -7 PER NCR14-3871	AJS	14.05.16
D	CHANGED FASTENER HOLES IN -5 FOR 1/4" HARDWARE. REASON: EASE OF INSTALLATION.	AJS	13.08.14
C	ADD -5.	AJS	13.08.08
B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D390-607-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	<b>D3910</b>	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>X-TUBE LUG (350)</b>	NTS
DATE	14.05.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



ROUND EDGE  
R0.06 MIN - R0.10 MAX  
2 PL

**SECTION A-A**



**RELEASED**

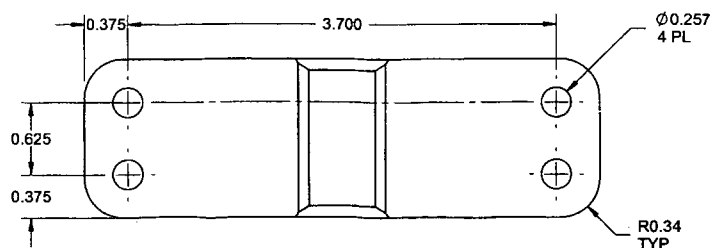
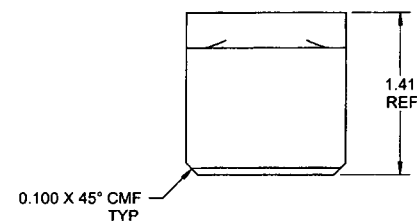
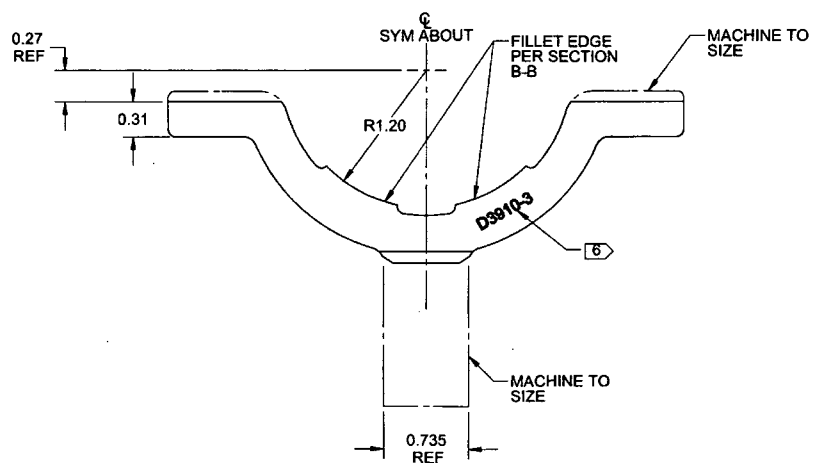
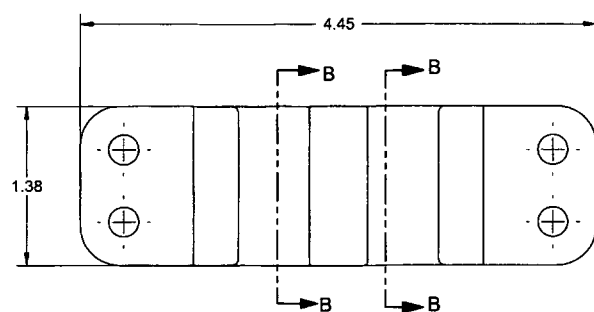
2014 JUN 05 *q*

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	<b>D3910</b>	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>X-TUBE LUG (350)</b>	NTS
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ROUND EDGE  
R0.06 MIN - 0.10 MAX  
2 PL

**SECTION B-B**



**D3910-3 X-TUBE LUG**

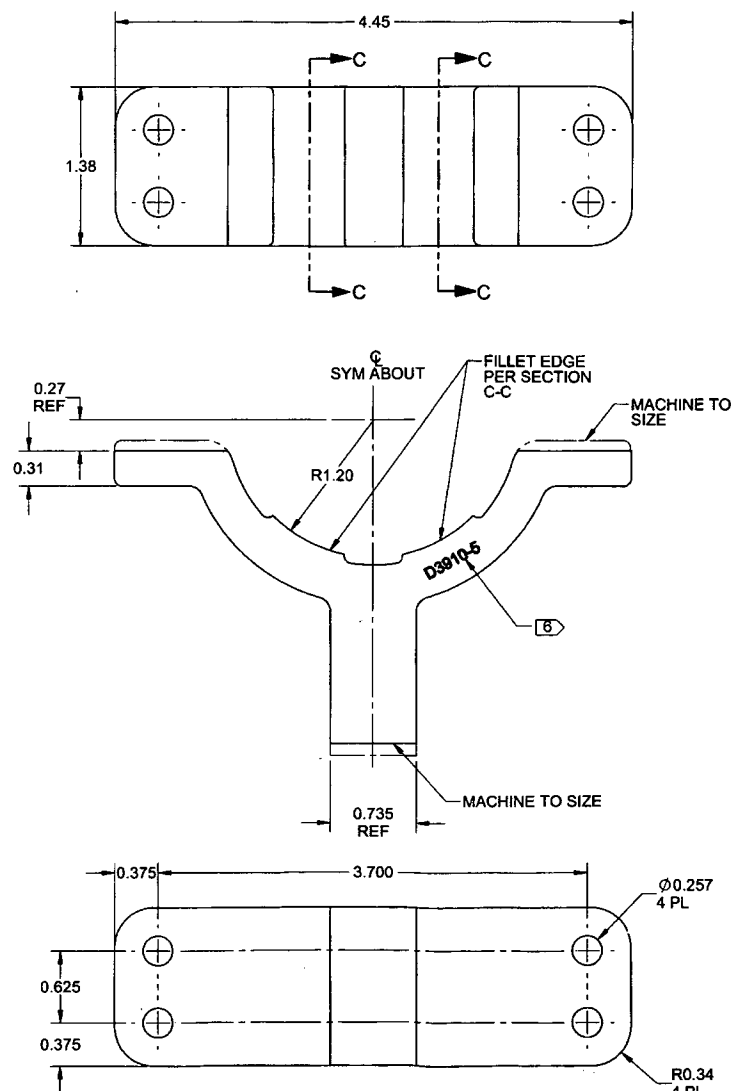
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**SECTION C-C**



ROUND EDGE  
R0.06 MIN - 0.10 MAX  
2 PL



**D3910-5 X-TUBE LUG**

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2014 JUN 05 *qp*

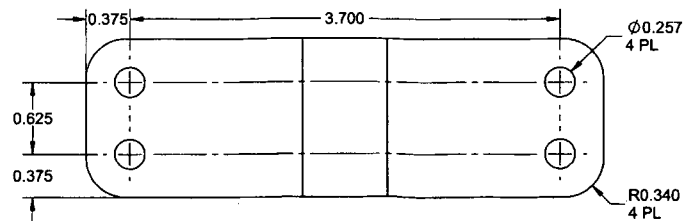
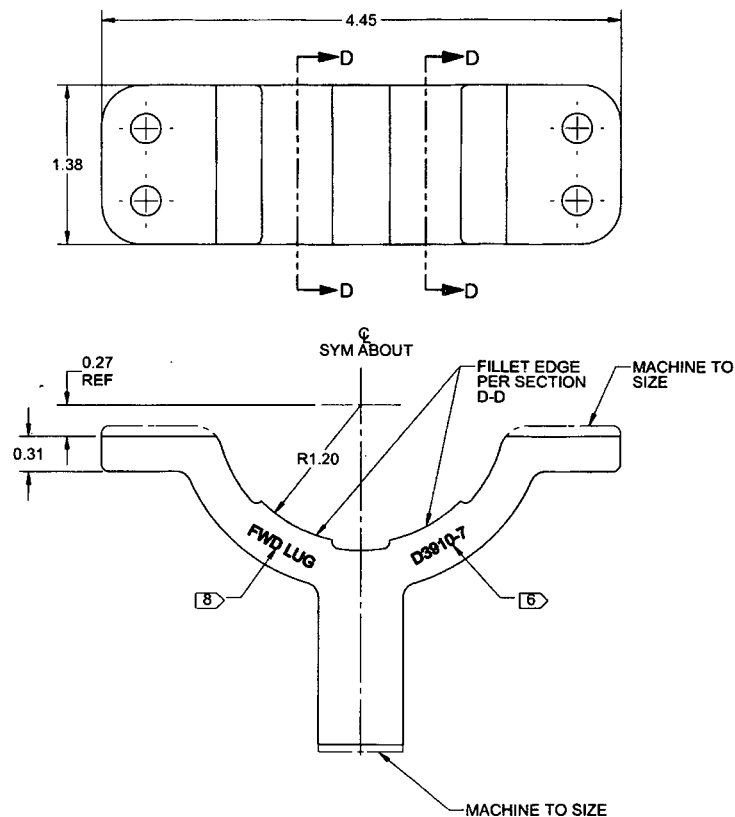
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DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3910</b>	REV. E SHEET 4 OF 5
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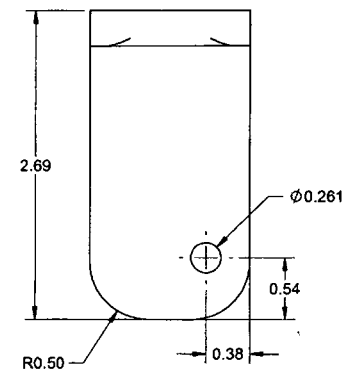
**SECTION D-D**



ROUND EDGE  
R0.06 MIN - 0.10 MAX  
2 PL



**D3910-7 X-TUBE LUG**



**RELEASED**

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